

Work Order ID 53888-2

November 23, 2009 11:24:00 AM



Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Item Name: Lug Assembly

Stop



Start Date: 23/11/2009 Start Qty: 20.00

Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-11-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

09-11-25

30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

09-11-25

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Serial 25

center  
x25

Take qty  
open  
inspect  
Temply  
8

# Work Order ID 53888

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Page 2

Item ID: D3405-043

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Stop



Start Date: 23/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr Form using DT8204 as per Dwg D3405

8/09/11/26

29

6

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

2) 8/09/11/26

route

408

6

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Weld as per Dwg D3405 Identify as D3405-043

EL 10-3-22 X 10

**Work Order ID 53888**

November 23, 2009 11:24:00 AM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 23/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6/10.03.24

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/03/24

410

180

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M113170

7 10/01/29

410

START TIME:

7:15AM

OVEN TEMPERATURE:

FINISH TIME:

400°F

# Work Order ID 53888

November 23, 2009 11:24:00 AM



Page 4

Item ID:	D3405-043	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug Assembly					
Start Date:	23/11/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
200 	Identify as per dwg & Stock Location: 474	0.00							
Packaging Packaging	Memo	0.00							
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/4/09 (10)

10/04/01

10-3-29 (10)



# Picklist Print

November 23, 2009 11:24:07 AM

Page 1

Work Order ID: 53888

Parent Item: D3405-043RevB

Parent Item Name: Lug Assembly

Comments:

Start Date: 23/11/2009

Required Date: 27/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3404-1RevC

Manufactured

No

100

Each

60.0000

20.0000



GHW Lug

*EL 10-3-22*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

45372

8

52515

1

52974

51

M304S11GA

Purchased

No

150

sf

126.2400

3.2421



304/316 0.125 Sheet

*Si*

*WB 9-11-25*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

126.24

112663

126.24

*112663*

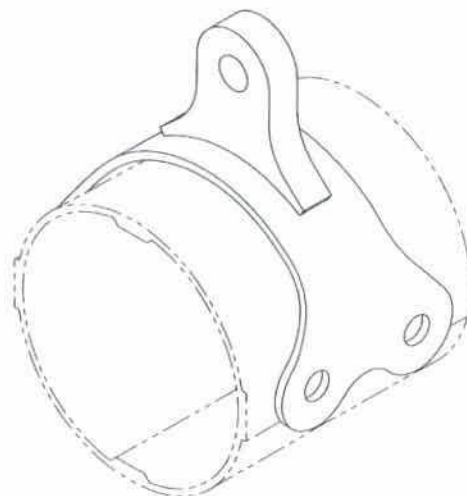
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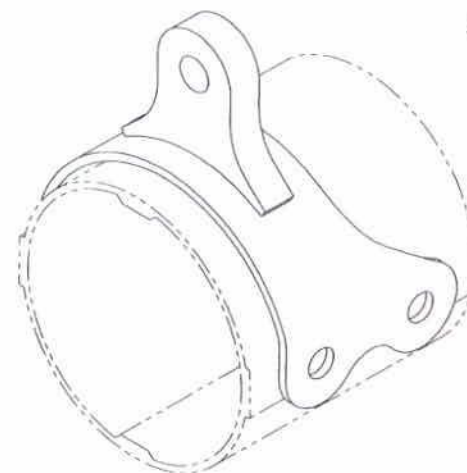
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

SHOWN  
 REWORK  
 ENGINE  
 UNCONTROLLED  
 SUBJECT TO APPROVAL  
 WITHOUT A TIME  
 WORK  
 NO. 53888  
 3409-11-23



**D3405-041 LUG ASSEMBLY**  
 (SKID TUBE SECTION SHOWN  
 FOR REF ONLY)



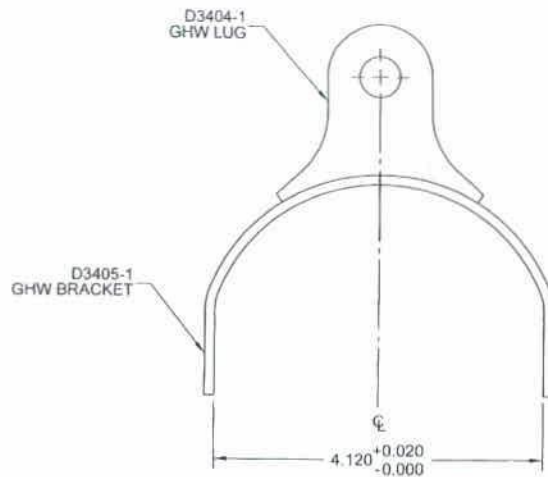
**D3405-043 LUG ASSEMBLY**  
 (SKID TUBE SECTION SHOWN  
 FOR REF ONLY)

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 08/12/18 M/S

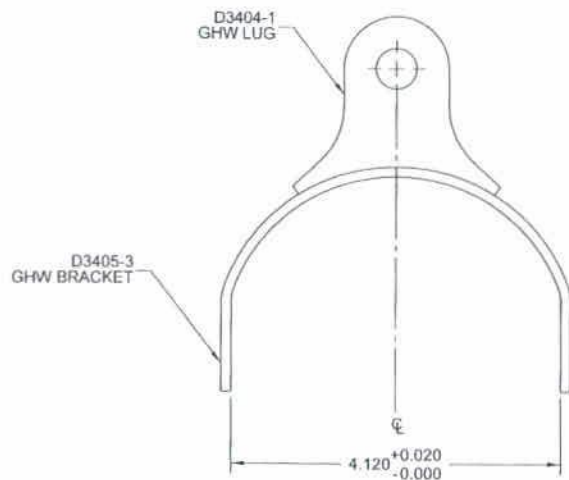
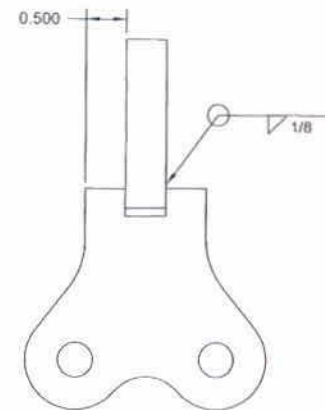
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
 ; IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
 -043, 0.87 lbs

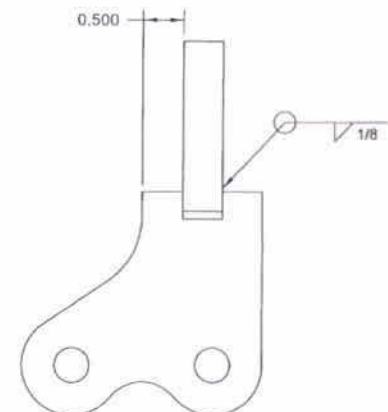
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198). SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4 100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3405</b> TITLE <b>GHW LUG ASSEMBLY</b> SCALE <b>NTS</b> COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TRANSACTION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED		REV. B	SHEET 1 OF 4	
DE APPR.				
DATE	08.09.19			



**D3405-041 LUG ASSEMBLY**



**D3405-043 LUG ASSEMBLY**

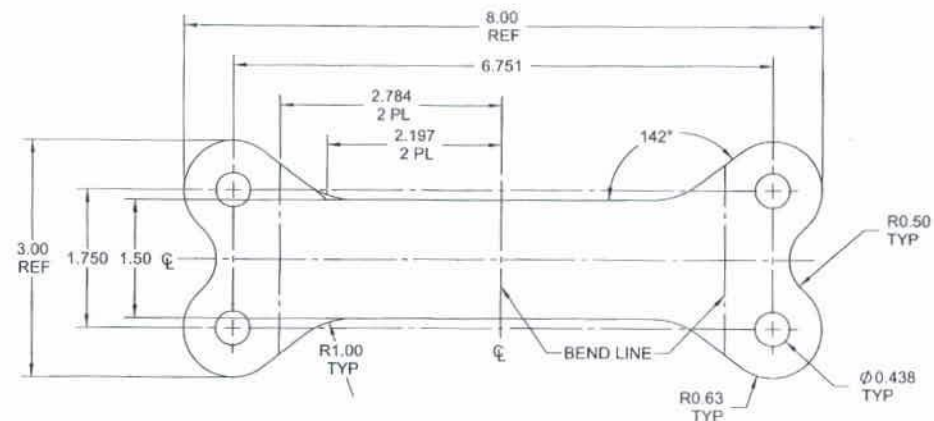


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6/12/18

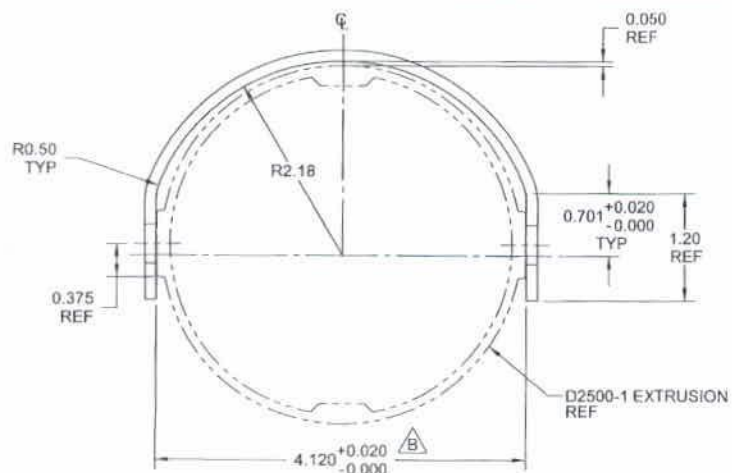
W10 53888

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DE APPR.			
DATE	08.09.19		

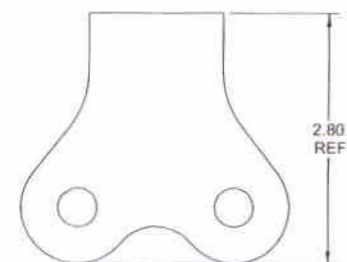




**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

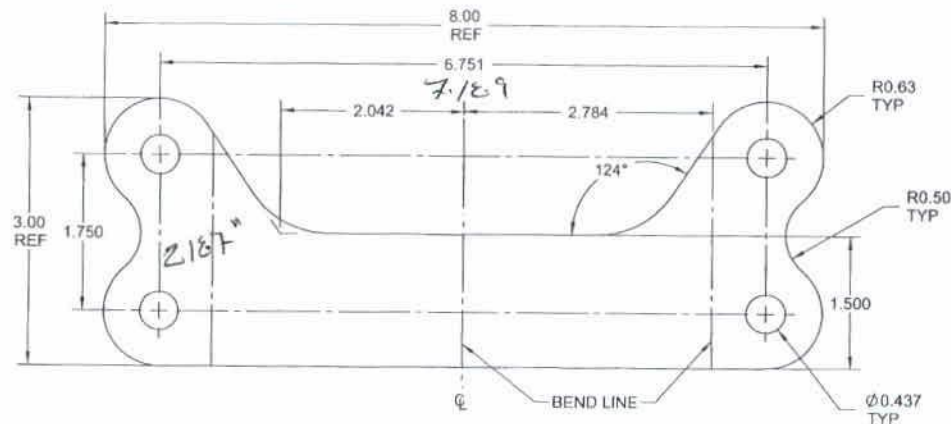
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

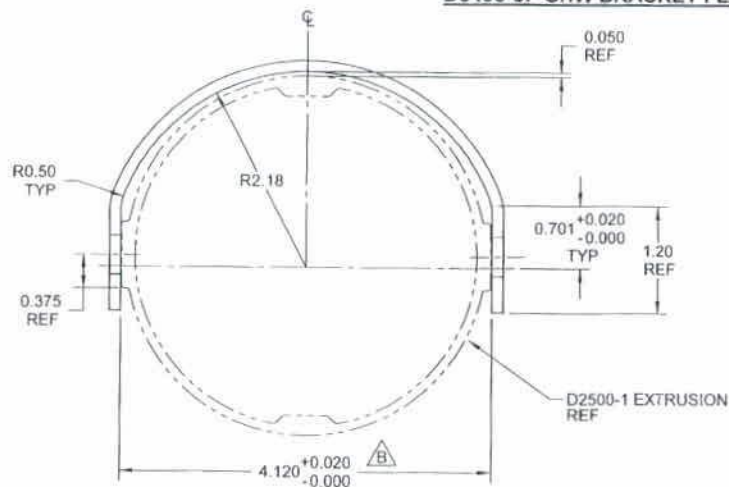
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DRAWN	ABS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
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ON 08/12/14

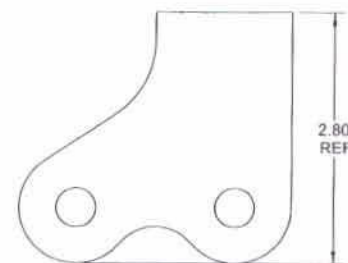
W10 53588



**D3405-3F GHW BRACKET FLAT PATTERN**



**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
08/12/18

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